

Work Order ID 122534

Tuesday, July 22, 2014 8:39:16 AM

122534

Page 1

Item ID: D3488-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Fitting LH

Stop

NS2

Start Date: 7/23/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/23/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-07-22

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3488	Rev B
DSK101	REV D

100	0.00	DAS
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100	DOOSAN LATHE	40
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Doosan	Memo	9-89
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Doosan Lathe	1-Turn as per Dwg DSK 101 & Folio FA625	14/08/10
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2-Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00	DAS
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110	Memo	40
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QC	0.00	9-89
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Quality Control		14/08/10
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PTO-D

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/08/10	100	2	The 2.620 Dim is at 2,598. Machine was Crashed By a previous Operator and The Turret is OUT of Alignment.			DAS 40 9-89 14/08/10		
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>	
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	<input type="checkbox"/>	
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>	
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	<input type="checkbox"/>	
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>	
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	<input type="checkbox"/>	
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>					
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>					
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>					
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>					

Work Order ID 122534

Tuesday, July 22, 2014 8:39:16 AM

122534

Page 2

Item ID: D3488-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Fitting LH

Stop

NS2

Start Date: 7/23/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/23/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
120

Operation
Description

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

11

1

MM

11/08/17

HAAS CNC vertical machine #1

1-Machine as per Folio FA625 & Dwg D34882-Deburr

130

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

130

QC

Memo

0.00

11

1

45

9-89

11/08/17

Quality Control

140

QC8- Inspect parts - second check

0.00

11/14/08/18

11

1

140

QC

Memo

0.00

NCR-P

DQA:

SP

Date: 14/12/13

QA Closed:

SP
Date: 14/12/9

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:	Part No.	NCR No.	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework	Scrap	Skid-tube	Crosstube	Water Jet	Engineering		
			Use-as-is	Machining	Small Fab	Prod. Eng. Coor.	Quality			
			Suspected Unapproved	Thermoforming	Finishing	Rec/Store/Packaging	Other			
				Large Fab	Composite	Supplier				
122534	D3488-041	14-4419								

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup	<i>X</i>	14/08/17	120	"y" origine was offset in first op - part could not fit in jig. (Op2) RC operation 5mm / was not Reversal.	DAS 16 9-89 Q52042 14/08/18	Scrap and destroy No replace	MH 14/08/17 \$ 258.32	<i>anf</i> 14/08/18	DAS 16 9-89 Q52042 14/08/18
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

Work Order ID 122534

Tuesday, July 22, 2014 8:39:16 AM

122534

Page 3

Item ID: D3488-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Fitting LH

Stop

NS2

Start Date: 7/23/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/23/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Hand Finishing

11 7/24/14-26

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

M 128934

Memo

0.00

START TIME:

8:55

OVEN TEMPERATURE:

300° FINISH TIME:

9:05

11 6/14-8-27. 34 38

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

11 6/14-8-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected Unapproved			Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced		
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up		
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure		
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld		
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled		
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>			
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other		
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread						
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set						
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration						
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence						

Work Order ID 122534

Tuesday, July 22, 2014 8:39:16 AM

122534

Page 4

Item ID: D3488-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Fitting LH

Stop

NS2

Start Date: 7/23/14 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 7/23/14 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

HandFinish

Hand Finishing

HandFinishing

0.00

✓11 φ 11 10/01/22

Memo

0.00

Install Inserts as per Dwg D3488

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

11 φ 14-08-22

DAS 34 9-89

200

200

Packaging

Packaging

Identify as per dwg & Stock Location: 1P-001

0.00

Memo

0.00

✓11 φ 11 10/01/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced		
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up		
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure		
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld		
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled		
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>			
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>			
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>			

Work Order ID 122534

Tuesday, July 22, 2014 8:39:16 AM

122534

Page 5

Item ID: D3488-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Fitting LH

Stop

NS2

Start Date: 7/23/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/23/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

210

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

210

QC

Quality Control

Memo

0.00

MUJ

14-07-23

Aug. 22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
						Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>	
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	<input type="checkbox"/>	
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>	
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	<input type="checkbox"/>	
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>	
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		<input type="checkbox"/>	Other
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	

Picklist Print

Tuesday, July 22, 2014 8:39:15 AM

Page 1

Work Order ID: 122534

122534
D3488-041

Parent Item: D3488-041

Parent Item Name: Blade Fitting LH

Start Date: 7/23/14

Required Date: 7/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No				Each	1,019.000		48	44	10/09/2014	

AI S7-1032-225

Insert

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FG	80	
	118520	80	
	FP001	852	
	m128649	852	
	ST280	87	
	m128179	87	

D6103-003 Manufactured No

D6103-003

Round Billet, Aluminum

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT043	24	
	113646	12	
	115942	4	
	116860	8	

14/08/10
40
8-89

DAS

40

8-89

PTO
D

DOA:

Aut

Date: 14/12/11

QA Closed:

SAG

Date: 14/12/10



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>122534</u>	Part No. <u>D3488-041</u>	NCR No. <u>14-4420</u>
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DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

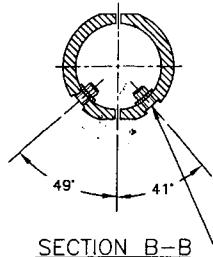
AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/12/11	100	2	Dim 2.620 is 2.600.	DAS 12 9-89	Acceptable	DAS 12 9-89	DAS 40 9-89	DAS 16 9-89
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric	Bend	Grain	Over/Under tolerance	Set-up
	Cracks	BOM/Route	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs	Burrs	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing	Contamination	Misaligned/off center	Positioned Wrong	
	Heat Treat	Countersink	Mislabeled	Power Loss/Surge	
	Inspection Strip in Tube	Cut Too Short	Misread		
	Marks/Chatter	Drawing	Off-set		
	Turning Sequence	Drill Holes	Out of Calibration		
	Wave/Twist in Tube	Finish	Out of Sequence		
		Fit/Function			

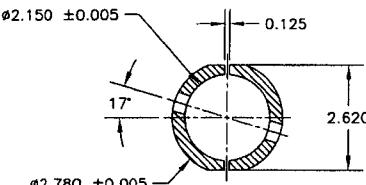


SECTION B-B

0.297
C'BORE $\phi 0.430 \times 0.100$
INSTALL ALS4-1032-225 (OR AKS4-1032-225)
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

122534 MLJ
14-07-22



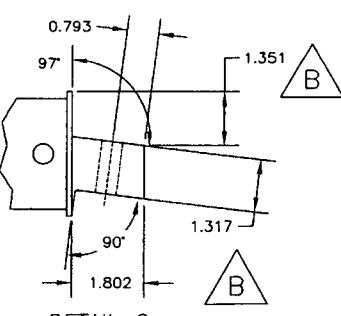
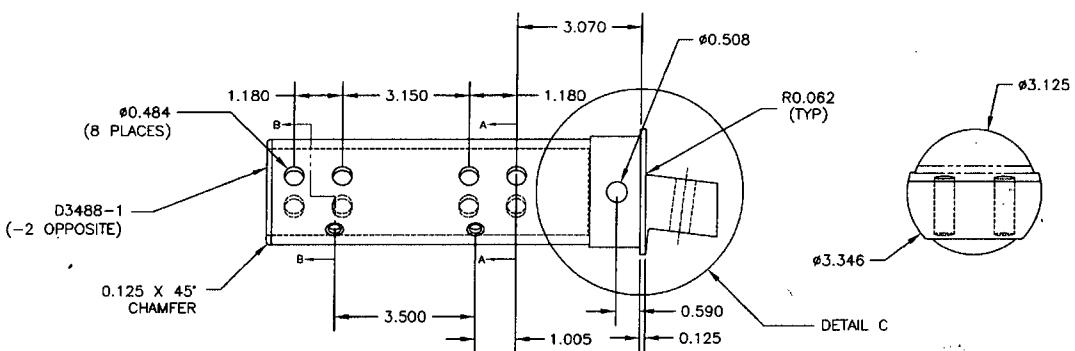
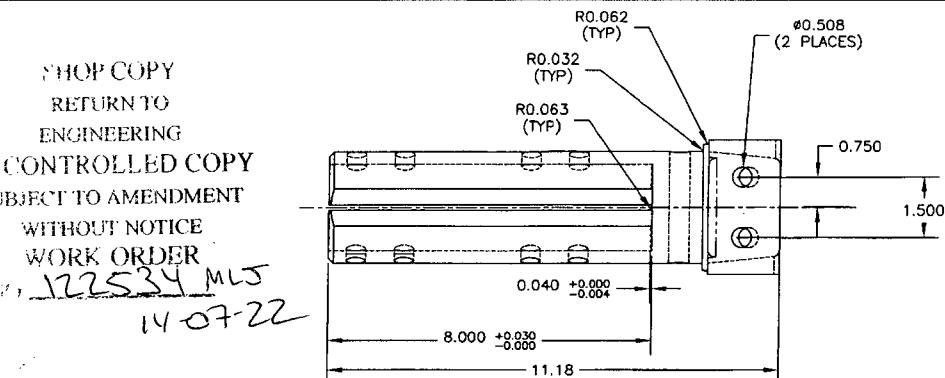
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
041	042	D3488-041	BLADE FITTING ASSEMBLY (LH)
X	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
1		D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06-03-04 PH
REF 05
ELN #787

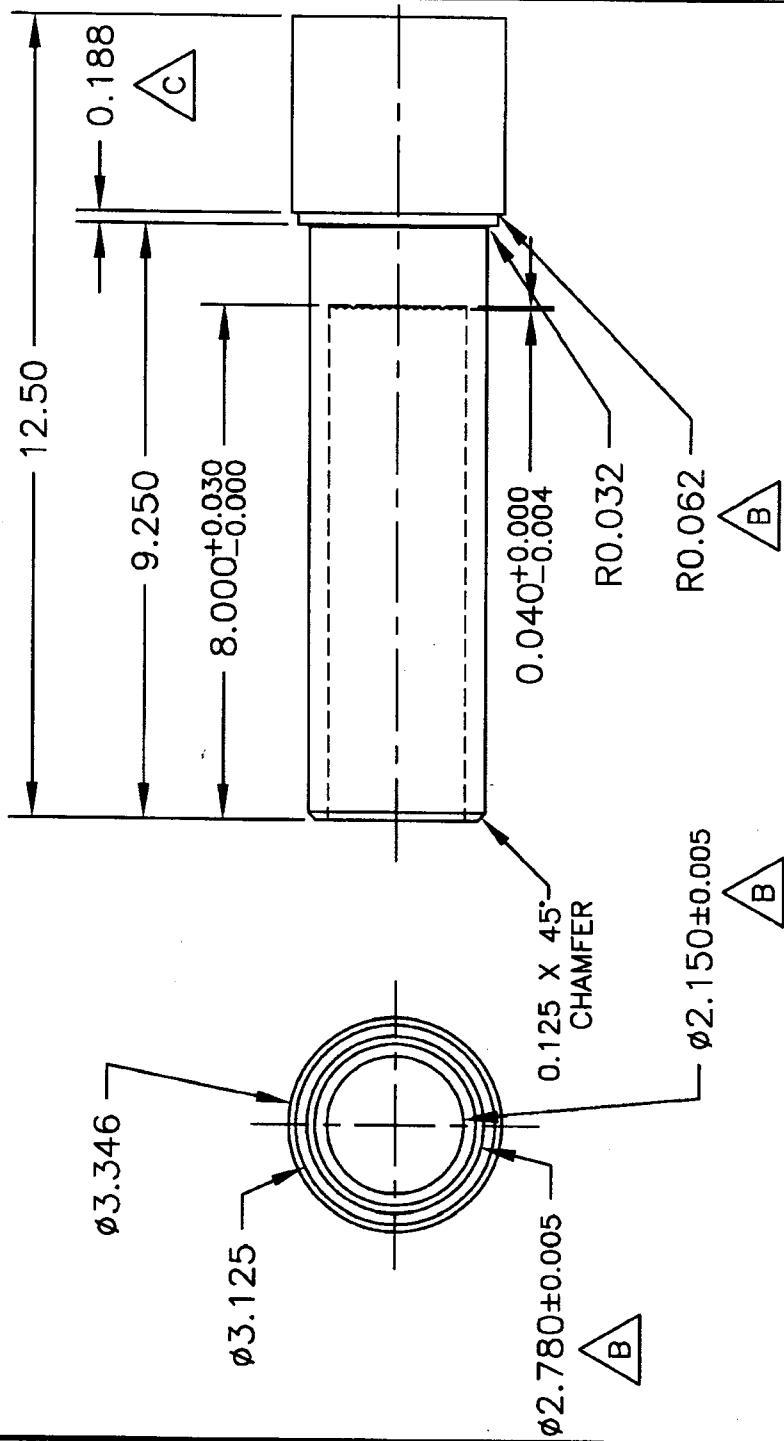
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B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE		DRAWING NO. D3488
06.03.15		REV. B
		SHEET 1 OF 1
		TITLE BLADE FITTING
		SCALE 1:3

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	PH	APPROVED	PH	DRAWING NO. DSK 101
DATE	06.05.09			REV. D SHEET 1 OF 1 SCALE 1:3
				TITLE D3488-1/-2 TURNING DETAIL
A	05.12.21	NEW ISSUE		
B	06.03.02	ADD TOLERANCES AND RADIUS		
C	06.04.17	0.188 WAS 0.125		
D	06.05.09	REMOVE DIAMETER FOR CHAMFER		

06.05.09 *PH*

DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
NONE
- 2) FINISH:
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order: 122534
Description: Blade fitting		Part Number: D3488-041
Inspection Dwg: D3488	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.346	± .010	3.346				
Ø 3.125	± .010	3.125				
Ø 2.780	± .005	2.780				
Ø 2.150	± .005	2.147				
.1250	± .030	.1250				
.9.250	± .010	9.248				
.8.000	± .030 - .000	8.010				
.188	± .010	.186				
.125x45°	± .010	.125				
Ø .297	± .006 - .001	.302				
Ø .430	± .010	.430				
.100	± .010	.100				
.125	± .010	.132				
.1.620	± .010	.1.621				
Ø .484	± .006 - .001	.485				
.1.180	± .010	.1.177				
3.150	± .010	3.147				
3.070	± .010	3.070				
3.500	± .010	3.498				
.1.005	± .010	.1.005				

DAS

Measured by:	40 9.89	Audited by:	<i>On</i>	Preliminary Approval:	
Date:	14/08/11	Date:	14/08/18	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	=

DART AEROSPACE LTD	Work Order:	122584
Description: Blade Fitting	Part Number:	D3488-PW
Inspection Dwg: D3488 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>MM</u>	Audited by: <u>cmf</u>	Preliminary Approval:
Date: 14/08/18	Date: 14/08/18	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	=